

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028854**Date Inspected:** 12-Dec-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Welder Mike Jimenez #4671:

Welder was observed performing weld repair on weld 13W PP123 W2.8-BF2 indication rejected with Ultrasonic Testing (UTSW) by QA Inspector at Y 320. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welding parameters as verified by QC Inspector Salvador Merino appear to be in compliance with the WPS noted above. Request for Weld Repair (RWR) is not required for R2 repair of non SPCM members.

Welder Wai Kit Lai #2953:

Welder was observed performing R1 interior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 10500 and 11260. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per "Request for Weld Repair" or (RWR) 201211-005. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above.

Welder Rick Chouinard #8959:

Welder was observed performing R1 exterior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 3000 and 4000. Welder was observed utilizing Welding

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Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per "Request for Weld Repair" or (RWR) 201211-005. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above.

Welder Rick Clayborn #2773:

Welder was observed performing R2 exterior weld repairs on weld 12E E2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors at Y 24310. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welding parameters as verified by QC Inspector John Pagliero appear to be in compliance with the WPS noted above. Weld section is non SPCM.

Non-Destructive Testing (NDT)

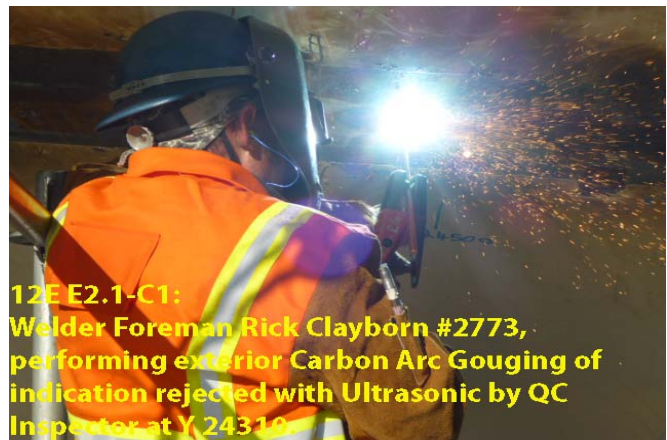
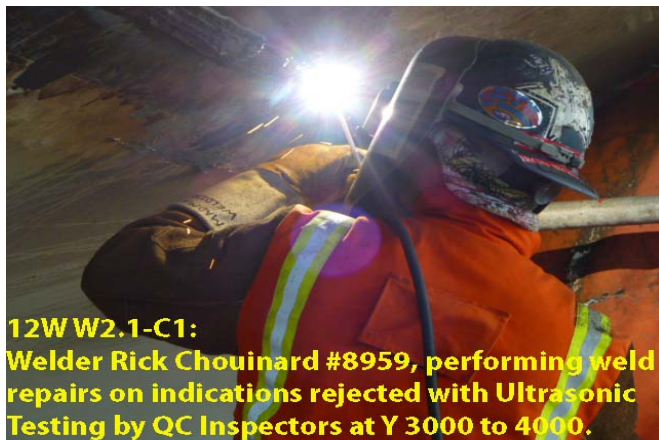
This QA performed Visual and Magnetic Particle Testing (MPT) on the following:

Weld 12E E2.1-C1:

- VT Weld Exterior Side at Y 0 to 9000 (VT Reject)
- MPT Weld Exterior Side at Y 0 to 9000 (MPT Accept.)

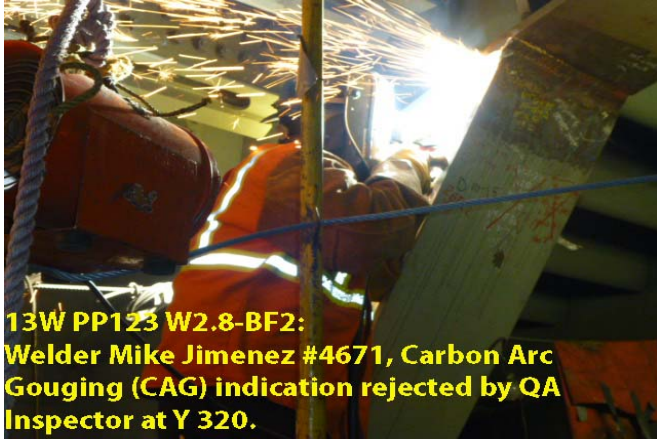
This QA Inspector completed the report form TL-6028 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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13W PP123 W2.8-BF2:
Welder Mike Jimenez #4671, Carbon Arc Gouging (CAG) indication rejected by QA Inspector at Y 320.



12W W2.1-C1:
Welder Wai Kit Lai #2953, performing interior R1 weld repairs on indications rejected with Ultrasonic Testing by QC Inspectors at Y 10500 to 11260.

Summary of Conversations:

Conversations this day as required for scope of work.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
